

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016201**Date Inspected:** 13-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 9EW:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: Seg057B-027 and 028. The welder is identified as 202384 and was observed welding in the 2F position. ZPMC Quality Control (QC) was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no's: Seg057C-011 and 012. The welder is identified as 049541 and was observed welding in the 2F position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 10AW:

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The FCAW process on weld joint no's: Seg059B-007 and 008. The welder is identified as 202384 and was observed welding in the 2F position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no's: Seg59C-013 and 014. The welder is identified as 049541 and was observed welding in the 2F position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 9BW:

Repair welding on weld joint no: Seg051C-001. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 047864 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 14553 Rev-0.

Cross Beam 12 (CB12):

Notification No: 06395.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG component - CB12. The weld designations reviewed are as follows:

- 1) CB201G-033-153 to 156.
- 2) CB201G-034-153 to 156.
- 3) CB201G-035-153 to 156.
- 4) CB201G-036-153 to 156.

Note:

- 1) CB 12 is identified as confined space.
- 2) NDT was delayed from 10:15 till 15:30; due to non availability of: electric supply, ventilation (blower) & grinder.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer